

# Work Order ID 88614

**\*88614\***

Page 1

August-02-12 1:46:05 PM

Item ID: D3883-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Outboard RH  
 Start Date: 7/23/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/08/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	C								

100

0.00

**\*100\***

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 88614

Double check by: \_\_\_\_\_

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

0.00

110

0.00

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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# Work Order ID 88614

August-02-12 1:46:05 PM

**\*88614\***

Page 2

Item ID: D3883-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Outboard RH  
 Start Date: 7/23/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
14  
9-89

12/10/23

4

0

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

4

12-10-23

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*140\***

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00  
3200 F  
2:30

4X

12/10/24

M122878

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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NCR: Yes / No

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# Picklist Print

August-02-12 1:46:04 PM

Page 1

Work Order ID: 88614

Parent Item: D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 7/23/12

Required Date: 7/27/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-015

Manufactured

No

Each

14.0000

4

Saddle Billet

Location

Loc Qty

Loc Code

MAT047

14

74800

4

85568

10

89823

24 12-10-21

4

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	88614
<b>Description:</b> Saddle, Outboard, RH		<b>Part Number:</b>	D3883-2
<b>Inspection Dwg:</b> D3883	<b>Rev.</b> C	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.643	.643	.643	.643		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.610	.610	.610	.610		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.002	2.002	2.002	2.002		
J	0.140	0.165		.153	.153	.153	.153		
K	0.240	0.260		.254	.254	.254	.254		
L	0.115	0.135		.122	.122	.122	.122		
M	0.140	0.165		.156	.156	.156	.156		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.249	.249	.249	.249		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.870	2.870	2.870	2.870		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.000	1.000	1.000	1.000		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.002	6.002	6.002	6.002		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.502	.502	.502	.502		
Y	1.220	1.280		1.240	1.240	1.240	1.240		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.316	.316	.316	.316		
AB	0.020	0.040		.020	.020	.020	.020		
AC	0.760	0.765		.763	.763	.763	.763		
AD	0.215	0.220		.217	.217	.217	.217		
AE	1.265	1.285		1.266	1.266	1.266	1.266		
AF									
Accept/Reject									

Measured by: <i>2d</i>	Audited by: <i>DA</i>
Date: <i>12-10-22</i>	Date: <i>12/10/23</i>

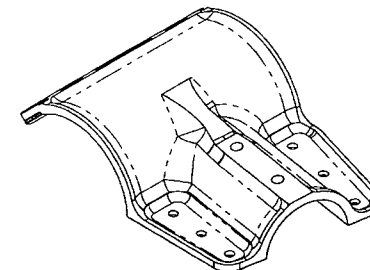
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	<i>[Signature]</i>

NO. 88614 MCT

R0.50  
TYP, 4 PL

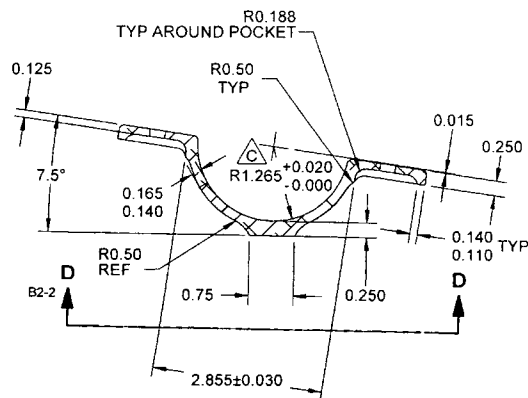


- 1) MATERIAL: 7075-T351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO  
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

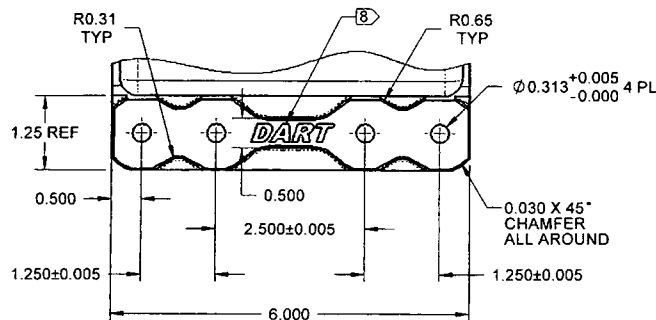


RELEASE  
2009-11-19  
*[Signature]*

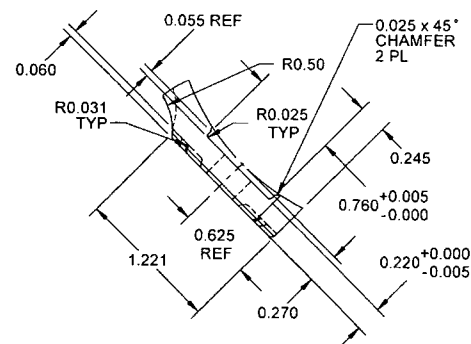
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015, ZN A7-1; ADD 0.648, ZN D7-1; ADD 0.815, ZN D6-1; ADD 0.125, ZN D7-2; ADD 0.060 & RD.031, ZN B5-2, 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D3883</b> TITLE <b>UPBOARD SADDLE</b> SCALE <b>NT</b>	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.		REV. _____ SHEET 1 OF _____ DATE <b>09.11.09</b>	
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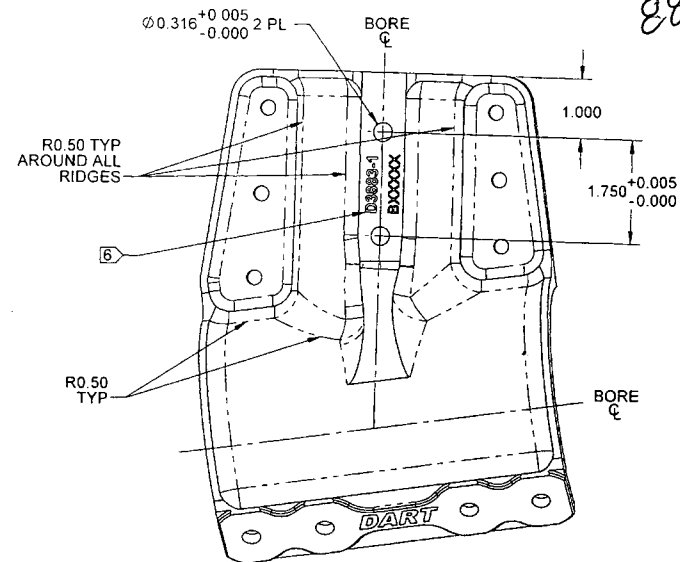
**SECTION A-A** C7-1



**VIEW B-B** B4-1  
(ROTATED FOR CLARITY)



**DETAIL C** B3-1  
SCALE 2X



**VIEW D-D** C7-2

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